

# EUROPEAN PATENT OFFICE

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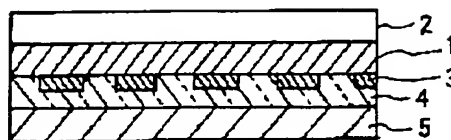
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TITLE : MANUFACTURE OF DECORATION  
SHEET



ABSTRACT : PURPOSE: To provide a decoration sheet having an excellent sharpness, printing property, processability, and ink coloring property even in the case of employing a thermoplastic resin such as a vinylchloride resin with low heat resistance.

CONSTITUTION: The decoration sheet 1 is made up of laminating a PVC film 5 on the surface of an adhesive layer 4 side of a PET film with the adhesive layer 4 and print pattern layer 3 laminated consecutively. A hard coat layer 2 such as an ultraviolet ray curable resin is applied and then cured on the easy adhesive surface of the PET film 1, then the PET film 1 is given a print pattern layer 3. Since the film 1 has a high heat resistance compared to the film 5, a heat treatment can be done for sufficiently eliminating a component of the solvent in the print pattern layer 3. Next, an adhesive layer 4 for adhering the films 1, 5 is applied thereon, however, no occurrence of expansion and sagging of the PET film is found by application of an adhesive and so on, and a heat-drying treatment of the adhesive layer 4 can be conducted under the condition capable of adequately removing a component of the solvent in the adhesive layer, and further even in the instance of putting the films 1, 5 into a lamination process, no turbidity and blister of the decoration sheet occur by the solvent and so on.

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